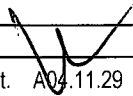
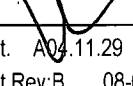


Date: Tuesday, 13/05/2008 10:09:25 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOUBLER
Job Number :	39185		
Estimate Number :	10636		
P.O. Number :		Part Number :	D3144119
This Issue :	13/05/2008	Drawing Number :	D3144 REV C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	C
Previous Run :	39185	Material :	
Written By :		Due Date :	30/05/2008
Checked & Approved By :		Qty:	4
Comment :	Est. A04.11.29 New issue KJ/RF Est Rev:B 08-05-12 now made on water jet DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S032	2024-T3 .032 sheet
-----	-------------	--------------------



Comment: Qty.: 0.0735 sf(s)/Unit Total: 0.2940 sf(s)
 2024-T3 .032 sheet
 Batch: 106272 IB 8-5-14

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3144
 Dwg Rev: C
 Prog Rev: C

IB 8-5-14

⑥

2-Deburr if necessary IB 8-5-14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-5-14

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

508/05/14 ④6

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

Done at step 5 08/05/14
 272

Date: Tuesday, 13/05/2008 10:09:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 39185

Part Number: D3144119

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

217/F2 08/05/14 (6)

7.0

POWDER COATING

POWDER COATING



M105642



(62)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*2:15
320° OF
2:02*

m-1 08/05/14

*30 min
15/05/2008
S.254 15.08
#1 317.5 F
#2 339.85 F
#3 03144119 F
#4*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-15 (X6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST143

AS 08/05/16 (X6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/05/2008

Job Completion



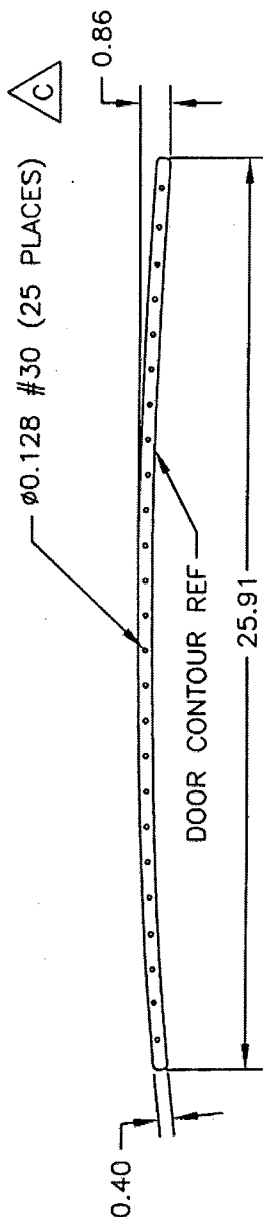
MF 08-05-16



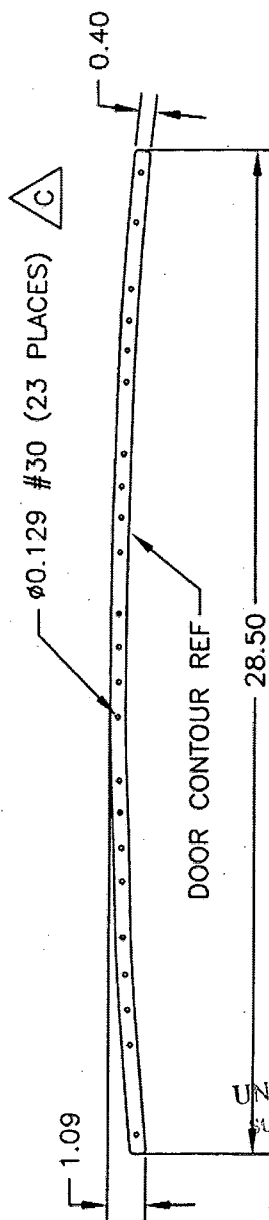
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CHECKED 		APPROVED 		DRAWING NO. D3144	REV. C SHEET 1 OF 9
DATE 05.10.19				TITLE DOUBLER	SCALE 1:5
A	02.04.22		NEW ISSUE		
B	04.09.17		ADDED D3144-105/-107/-109/-111/ -115/-121/-123; MODIFY D3144-1		
C	05.10.19		ADD D3144-15; ø0.129 WAS ø0.098		

RELEASED

05.11.14



D3144-1 DOUBLER (FOR D412-694-03)
REPLACES PREMIER P/N B30-23000-191



D3144-3 DOUBLER (FOR D412-694-01)
REPLACES PREMIER P/N B30-23000-193

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D3144-1/-3 NOTES:

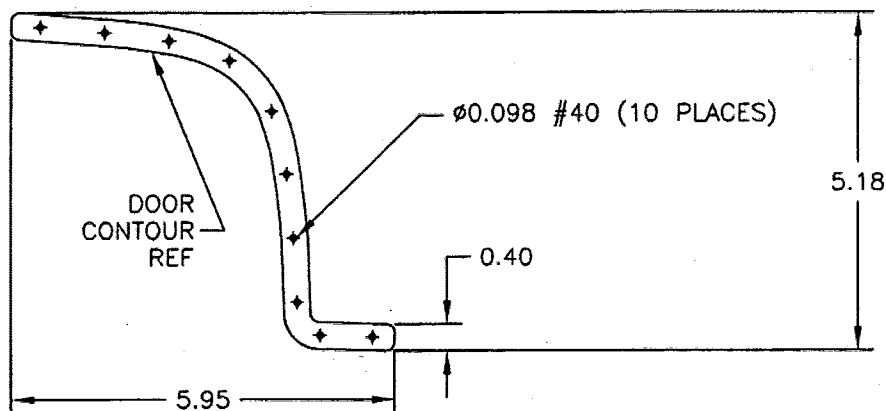
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C1.DWG"

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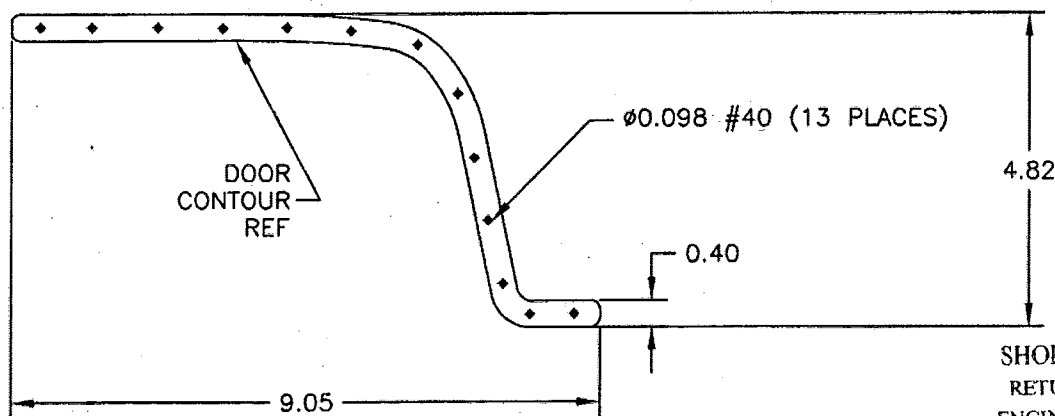
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS



D3144-5 DOUBLER
REPLACES PREMIER P/N B30-23000-195



D3144-7 DOUBLER
REPLACES PREMIER P/N B30-23000-197

D3144-5/-7 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C2.DWG"

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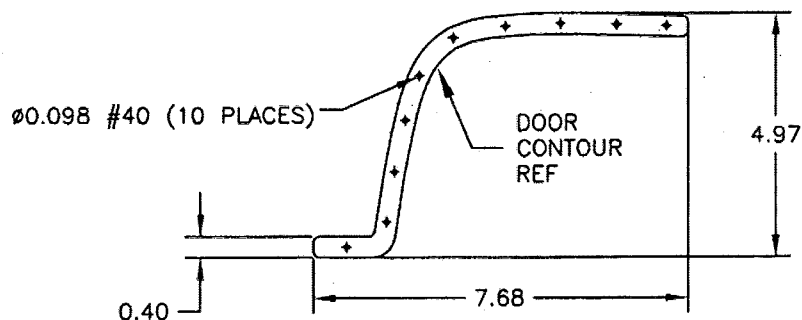
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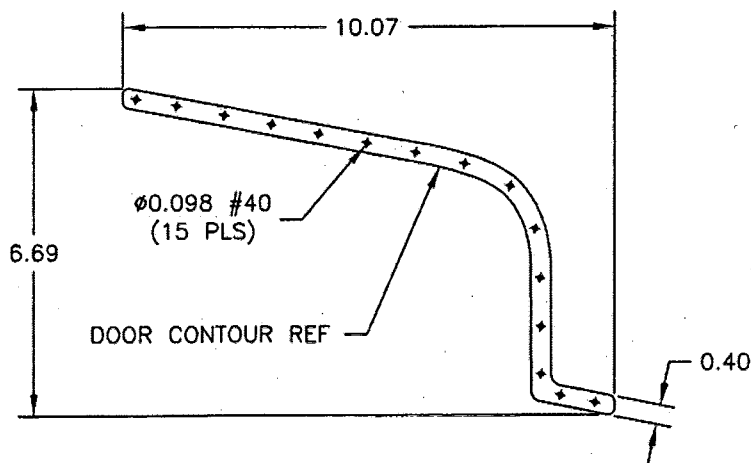


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DATE 05.10.19	TITLE DOUBLER		SCALE NTS



D3144-9 DOUBLER

REPLACES PREMIER P/N B30-23000-199



D3144-11 DOUBLER

REPLACES PREMIER P/N B30-23000-203

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D3144-9/-11 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C3.DWG"

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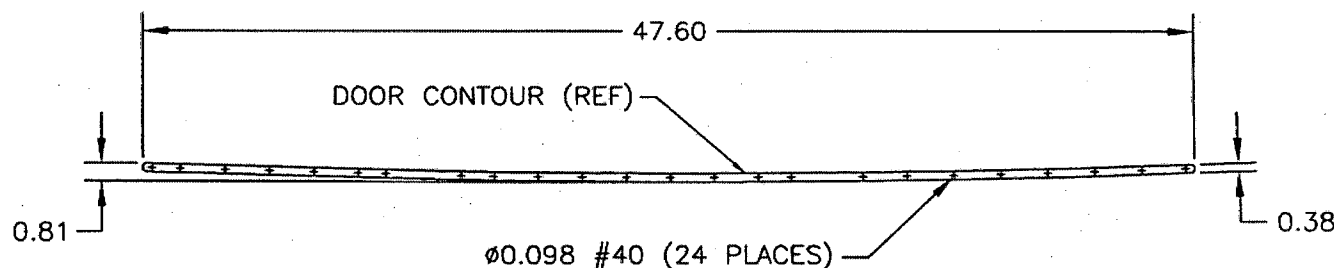
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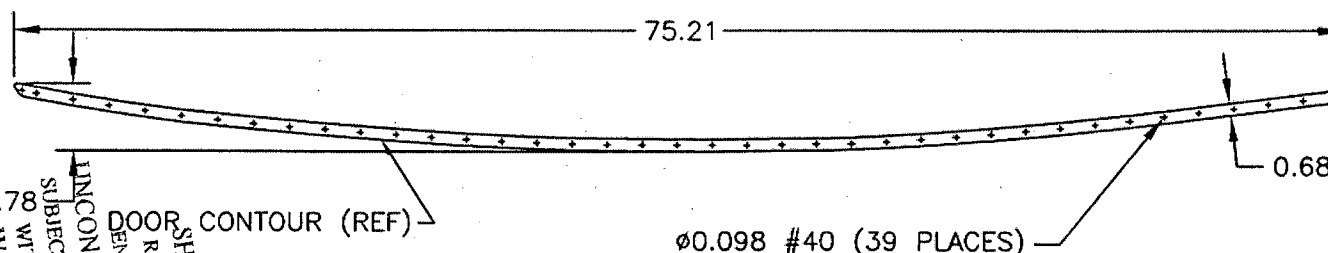


D3144-15 DOUBLER
SCALE 1:8



D3144-15 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"



D3144-13 DOUBLER
SCALE 1:10

REPLACES PREMIER P/N B30-23000-211



D3144-13 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.020 THICK (REF DART SPEC M2024T3S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"

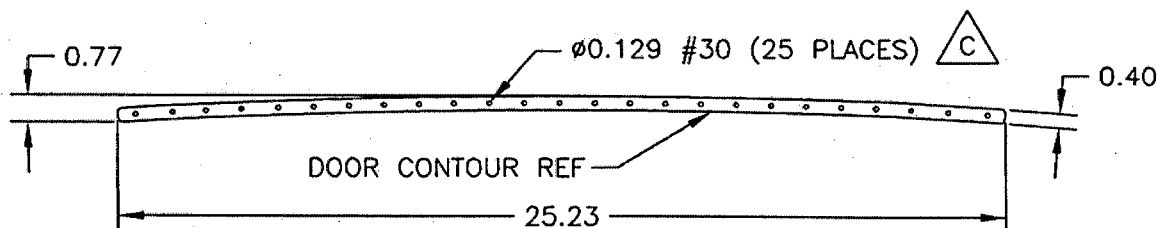
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DATE	TITLE	REV. C
05.10.19	DOUBLER	SHEET 4 OF 9
		SCALE
		NTS

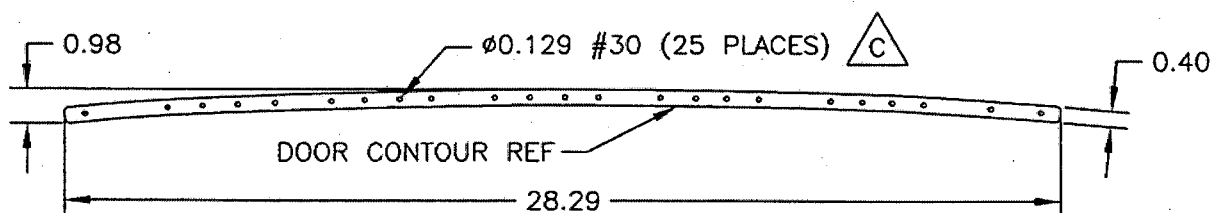
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DATE	05.10.19	TITLE	DOUBLER	REV. C SHEET 5 OF 9

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D3144-119 DOUBLER (FOR D412-694-04)



D3144-123 DOUBLER (D412-694-02)

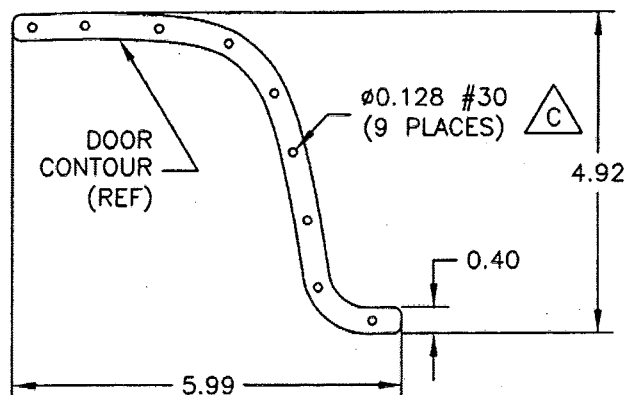
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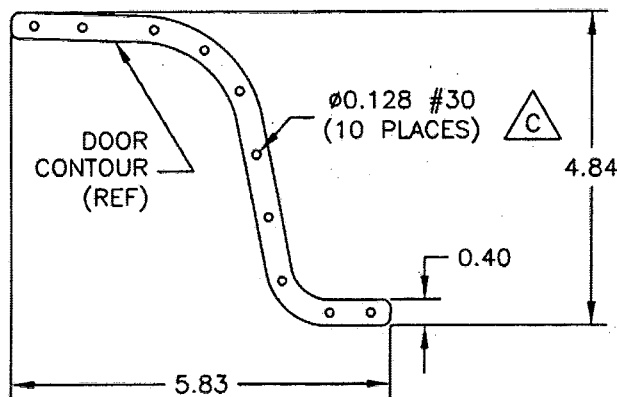
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C5.DWG"



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D3144-105 DOUBLER (FOR D412-694-03)



D3144-117 DOUBLER (FOR D412-694-04)

RELEASED

05-11-14 #

D3144-105/-117 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C6.DWG"

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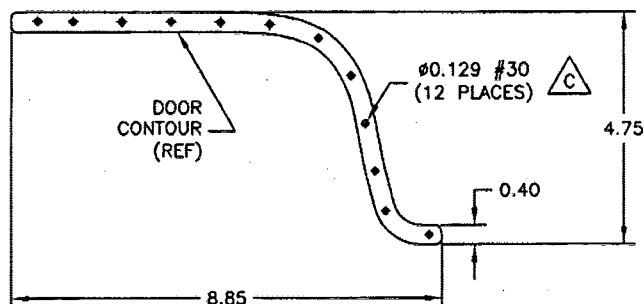
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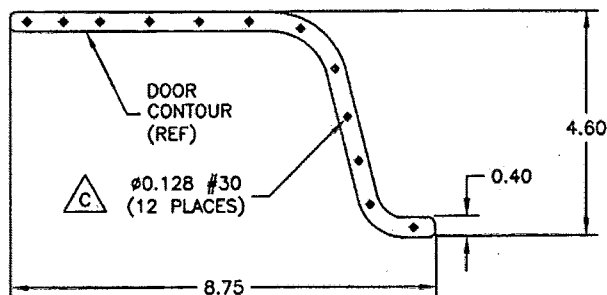
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS



D3144-107 DOUBLER (FOR D412-694-03)



D3144-121 DOUBLER (FOR D412-694-04)

RELEASED

05.11.14 *[Signature]*

D3144-107/-121 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
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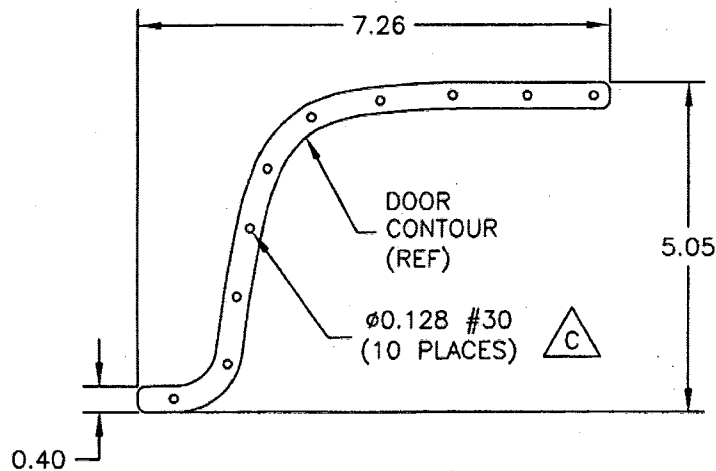
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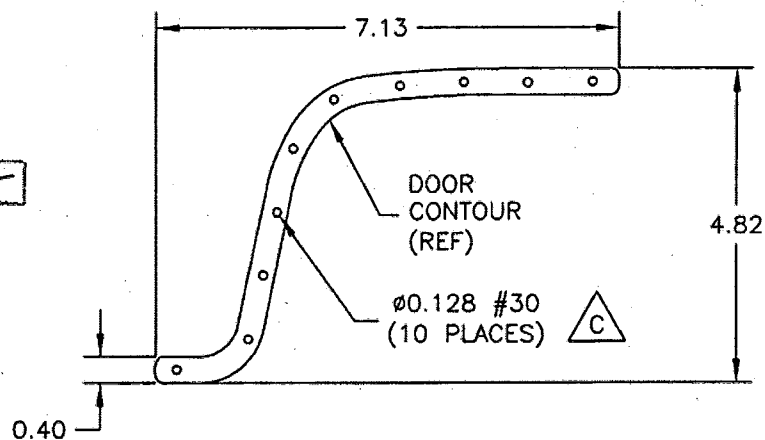
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS

**D3144-109 DOUBLER (FOR D412-694-01)****RELEASED**

05.11.14

**D3144-115 DOUBLER (FOR D412-694-02)****D3144-109/-115 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3SI032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C8.DWG"

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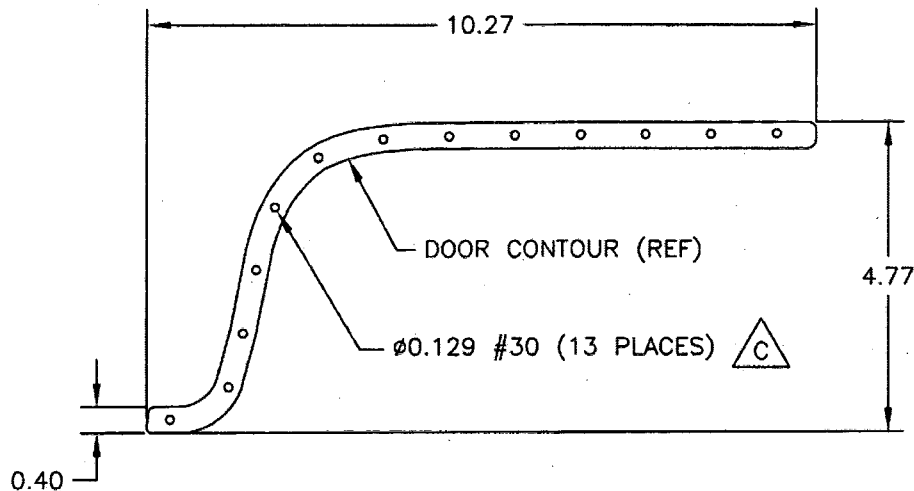
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS

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D3144-111 DOUBLER (FOR D412-694-01/-02)

D3144-111 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C9.DWG"

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